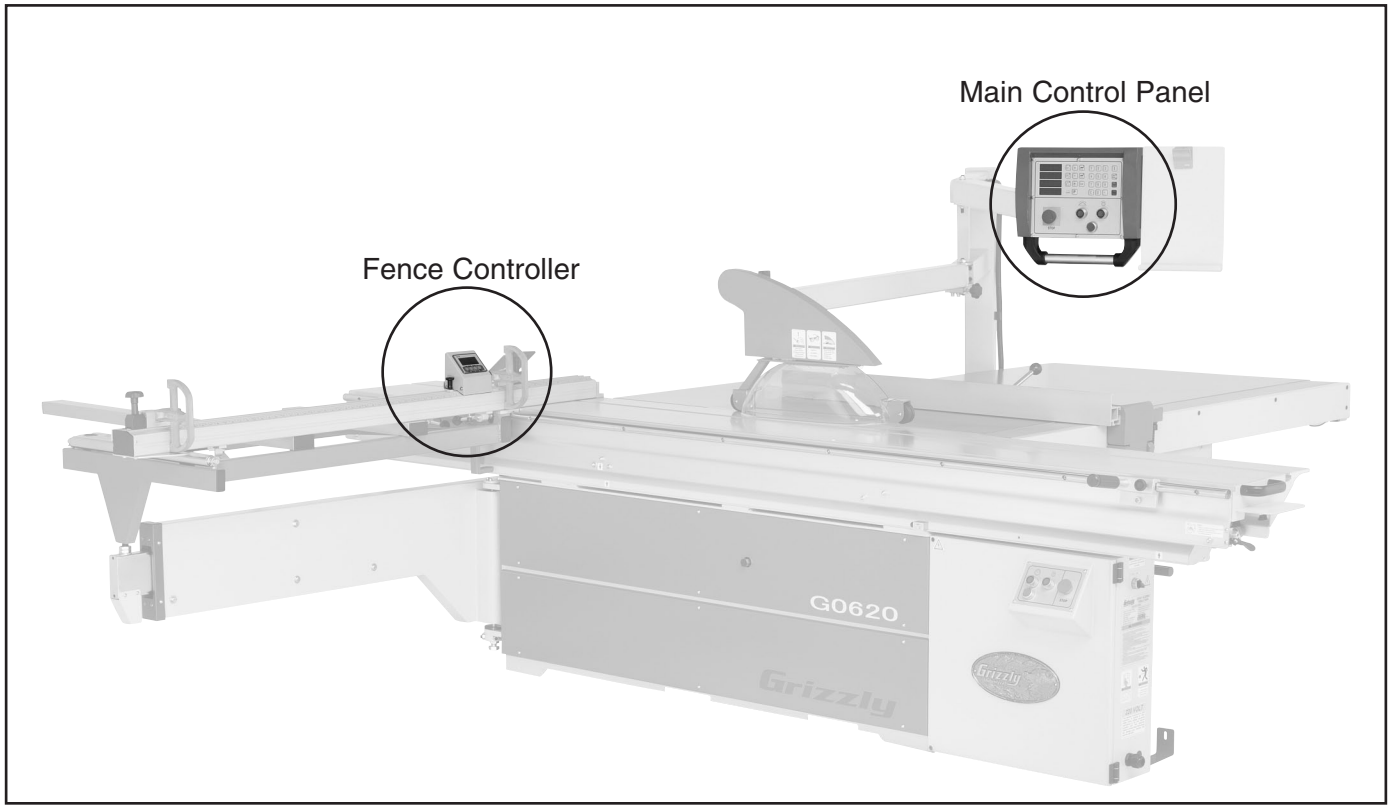
MODEL G0620
SUPPLEMENT MANUAL FOR DIGITAL CONTROLS



#TR10571 PRINTED IN USA

Table of Contents

INTRODUCTION

Foreword

Both controllers covered in this manual have capabilities beyond their use with the Model G0620. For that reason, you may find functions or features that will never be used with your saw.

Aside from instructional clarity, this manual aims to filter out the applicable features from the non-applicable features of these controllers, so you can quickly understand the functions you need to get your machine up and running. Also, the complete factory manual for the controllers are still included with your machine, in case you need them.

The specifications, drawings, and photographs illustrated in this manual are current when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

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MAIN CONTROL PANEL OPERATIONS

Control Panel Identification

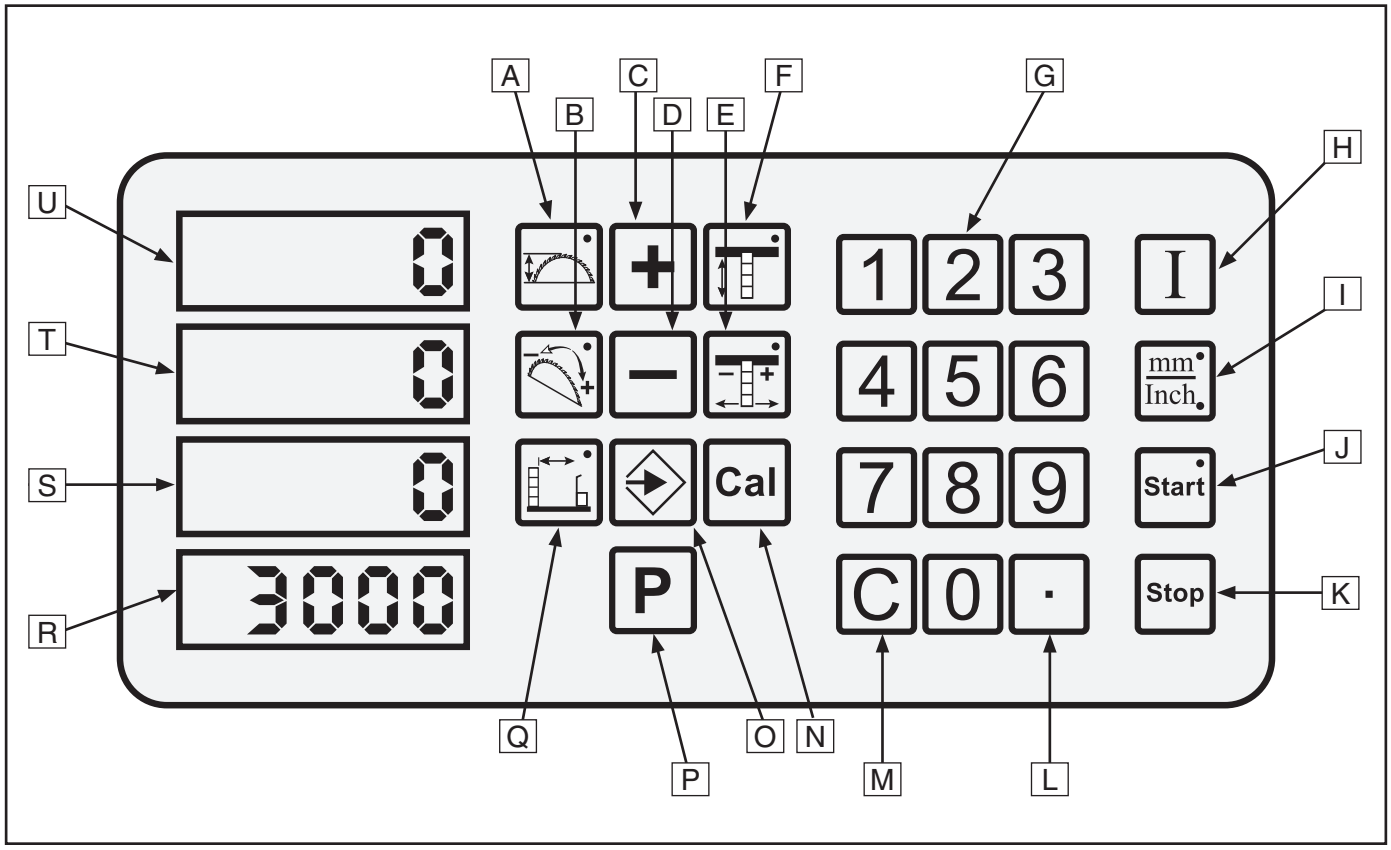

Figure 1. Control panel identification.

A. Blade Height Key
B. Blade Tilt Key
C. Manual Increase Key
D. Manual Decrease Key
E. Scoring Blade Alignment Key
F. Scoring Blade Height Key
G. Number Keys
H. Input Confirmation Key
I. Millimeter/Inch Selection Key
J. Start Key
K. Stop Key
L. Decimal Key
M. Clear Key
N. Function Confirmation Key
O. Memory Set Key
P. Pre-Saved Memory Recall Key
Q. Cutting Width Key
R. Memory Set and Speed Display
S. Cutting Width Display
T. Blade Angle Display
U. Blade Height Display

Quick Start

Manual Adjustments

The components controlled by the keys in **Figure 2** can be manually adjusted using the [+] and [−] keys.

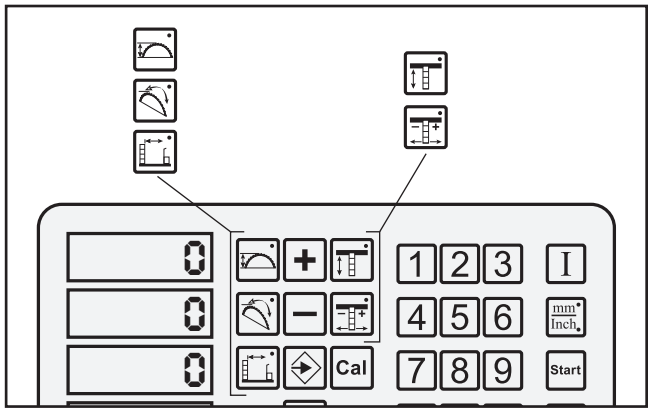

Figure 2. Controls keys capable of manual operation.

To manually adjust any of these components, press one of the control keys shown in **Figure 2** so its indicator light shines, then press [+] or [−] as desired to manually position the related control. When finished, press the control key again so its indicator light stops shining.

Note: *You can press the Stop [Stop] key at any time to cancel the operation.*

Only the blade height [ ], table tilt [ ], and cutting width [ ] controls allow numerical input. The scoring blade height [ ] and scoring blade alignment [ ] controls must be adjusted by eye or by an independent guide, such as a straightedge.

Typically manual controls are used when mathematical adjustments are not practical, such as those adjustments done by eye or when setting the components to a marked workpiece.

Numerical Input Adjustments

The components controlled by the keys in **Figure 3** can be controlled by numerical input and will automatically adjust to the dimension you entered. For more details on controlling any one component, refer to the **Section 3: Operations**.

Note: *You can press the Stop [Stop] key at any time to cancel the operation.*

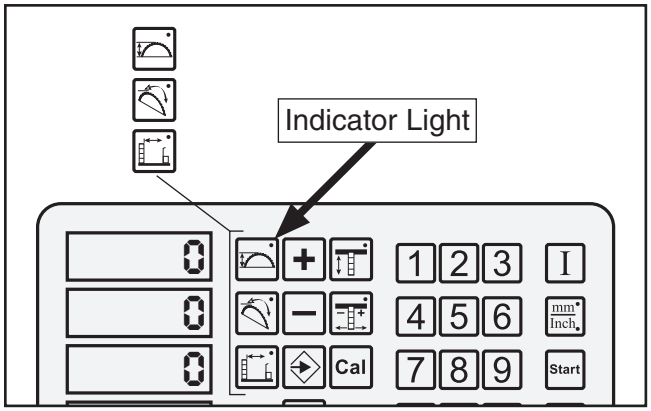

Figure 3. Controls capable of being moved by numerical input.

To move the components with numerical input:

1. Press the desired control key ([ ], [ ], and [ ]) for the component that you want to move.

   The indicator light on the key (**Figure 3**) shines to tell you that the control panel is ready to accept your input.

2. Enter your input with the number keypad.

   As you press the keys, the display will flash the numbers you have entered.

   Example: If your input is 2.15", then you would press the following keys: [2] [·] [1] [5].

3. Press the Start [Start] key and the component will move to where it is directed by your input.

MM/Inch Selection

The control panel can display units in millimeters or inches.

To toggle the display between mm and inches, press and hold the mm/inch key (**Figure 4**) until the new unit of measure shows on the control panel.

Note: *The indicator light on the key shines next to the unit of measure selected.*

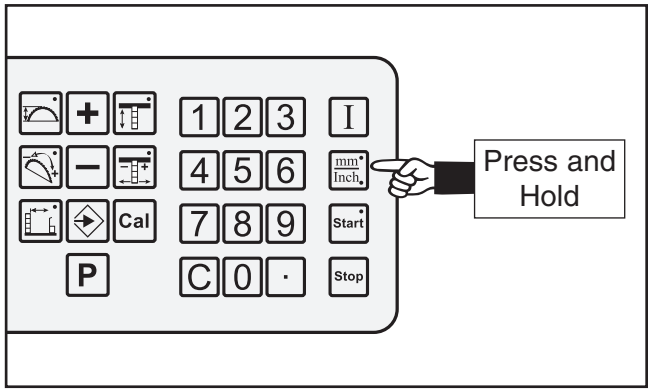

Figure 4. Pressing mm/inch key to toggle the displayed unit of measure.

Scoring Blade Adjustments

Figure 5 shows the keys used to adjust the scoring blade, as discussed in this procedure. You can press the Stop key at any time to cancel the operation.

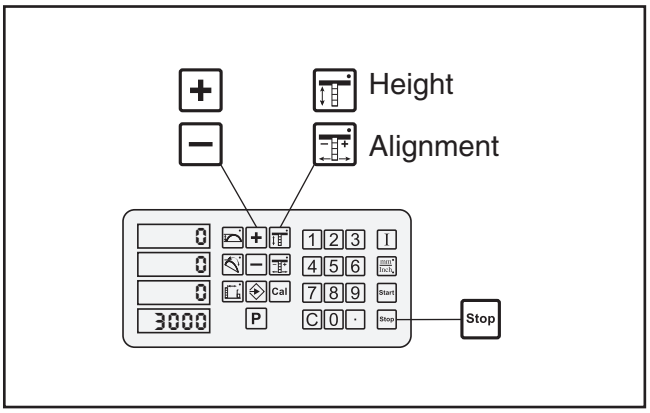

Figure 5. Scoring blade controls keys.

Scoring Blade Height

1. Press the scoring blade height control key.

   The indicator light on the key shines to show the selected control is active.

2. Use the plus and minus keys to position the scoring blade. Typically, the scoring blade is only adjusted about ¼"–½" above the table.

3. When finished, press the Stop key, so the indicator light stops shining.

Scoring Blade Alignment

1. Press the scoring blade alignment control key.

   The indicator light on the key shines to show the selected control is active.

2. Use the plus and minus keys to align the scoring blade with the main blade. (Use a straightedge or the rip fence as a guide.)

3. When finished, press the Stop key, so the indicator light stops shining.

Blade Height Adjustments

The blade height can be adjusted manually or numerically by entering in the desired blade height. The adjustment can be cancelled at any time by pressing the Stop [Stop] key.

Figure 6 shows the keys used during the blade height adjustment procedures in this section.

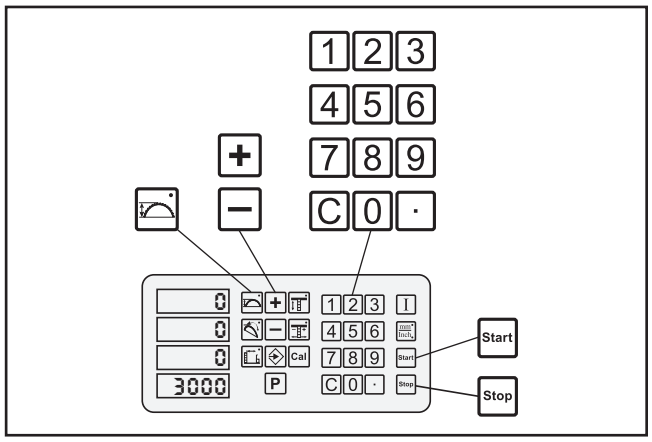

Figure 6. Keys used in blade height adjustment procedures.

Manually Adjusting Blade Height

The blade height can be manually adjusted using the plus [+] and minus [−] keys. In some cases, manual adjustments can save time by eliminating measurements. For example, if you want to adjust the blade height a little higher than the workpiece, you can place the workpiece next to the blade and use the manual controls to adjust the blade height as desired.

To adjust the blade height manually:

1. Press the blade height control key.

   The indicator light on the key shines to show that the control panel is ready for input.

2. Use the plus [+] or minus [−] key to manually position the blade height. (Bump the keys for small adjustments and hold the keys down for large adjustments.)

3. When finished, press the Stop [Stop] key, so the indicator light stops shining.

Numerically Adjusting Blade Height

You can enter a desired blade height with the number keys and the blade will automatically adjust to that height.

To adjust the blade height automatically with numerical input:

1. Press the blade height control key.

   The indicator light on the key shines to tell you that the control panel is ready to accept your input.

2. Enter your numerical input with the number keys. As you press the keys, the display will flash the numbers you have entered. If you press a wrong number or make a mistake with your input, press the clear [C] key and start over.

   Example: If you want the blade height to be 2.25", then you would press the following keys: [2] [·] [2] [5], and the display would look similar to **Figure 7**.

   Note: *It may be necessary to enter a zero first if your numerical input is less than one.*

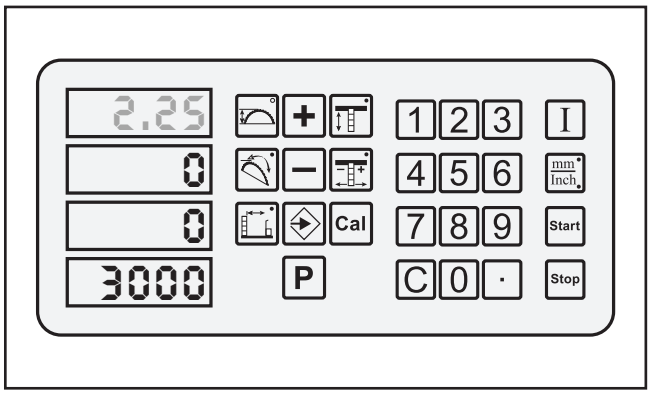

Figure 7. Example of 2.25" entered into blade height display.

3. Press the Start [Start] key.

   The control panel accepts your input, moves the blade to your desired height, and the indicator light on the blade height key stops shining.

Blade Tilt Adjustments

The blade tilt can be adjusted manually or automatically with numerical input. The adjustment can be cancelled at any time by pressing the Stop [Stop] key.

Figure 8 shows the keys used during the blade tilt adjustment procedures in this section.

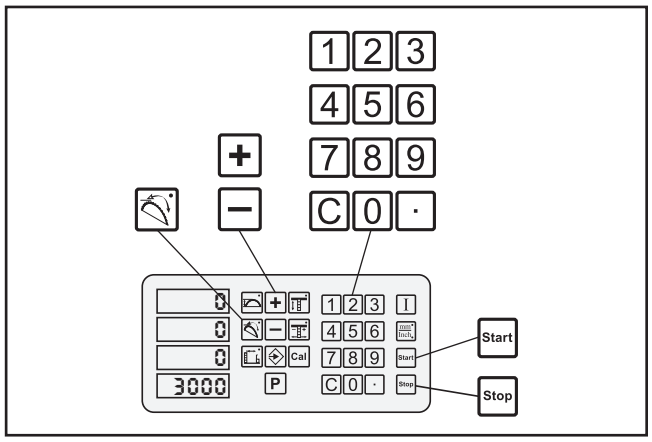

Figure 8. Keys used in blade tilt adjustment procedures.

Manually Adjusting Blade Tilt

The blade tilt can be manually adjusted using the plus [+] and minus [−] keys. In some cases, manual adjustments can save time by eliminating measurements. For example, if you want to adjust the blade tilt to match an existing mitered cut, you can place the workpiece next to the blade and use the manual controls to adjust the blade tilt as desired.

To adjust the blade tilt manually:

1. Press the blade tilt control [◿] key. The indicator light on the key shines to show that the control panel is ready to accept input.

2. Use the plus [+] or minus [−] key to manually position the blade tilt. (Bump the keys for small adjustments and hold the keys down for large adjustments.)

3. When finished, press the Stop [Stop] key, so the indicator light stops shining.

Numerically Adjusting Blade Tilt

You can enter a desired angle with the number keys and the blade will automatically adjust to that angle.

To adjust the blade tilt automatically with numerical input:

1. Press the blade tilt [◿] key.

   The indicator light on the key shines to tell you that the control panel is ready to accept your input.

2. Enter the desired blade tilt with the number keys. As you press the keys, the display will flash the numbers you have entered. If you press a wrong number or make a mistake with your input, press the clear [C] key and start over.

   Example: *If you want the blade tilt to be 22.5", then you would press the following keys: [2] [2] [·] [5], and the display would look similar to* ***Figure 9****.*

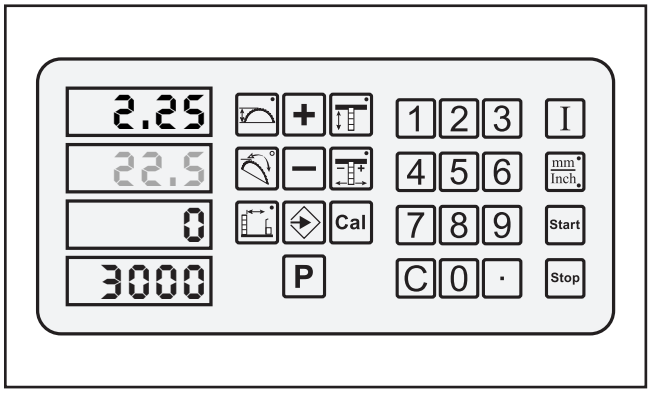

Figure 9. Example of 22.5° entered into blade tilt display.

3. Press the Start [Start] key. The control panel accepts your input, moves the blade to your desired tilt, and the indicator light on the blade tilt key stops shining.

NOTICE

Changes to the blade tilt affect blade height. After performing Step 3, the blade height will be different than shown in Figure 9. To save time of having to re-enter the blade height, enter the blade tilt before entering blade height.

Rip Fence Adjustments

The rip fence can be adjusted manually or automatically with numerical input. The adjustment can be cancelled at any time by pressing the Stop [Stop] key.

Figure 10 shows the keys used during the rip fence adjustment procedures in this section.

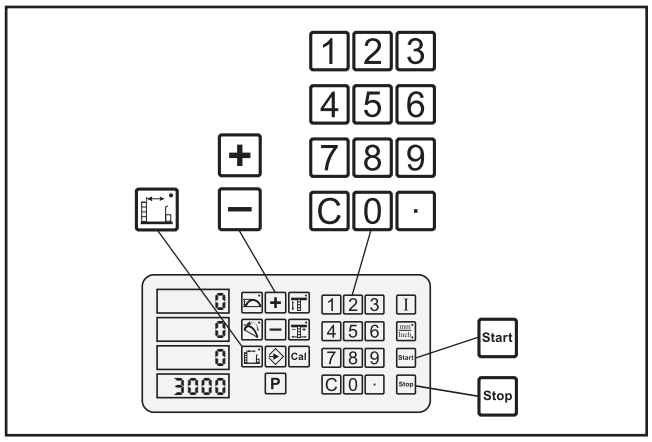

Figure 10. Keys used in rip fence adjustment procedures.

Manually Adjusting Rip fence

The rip fence can be manually adjusted using the plus [+] and minus [−] keys. In some cases, manual adjustments can save time by eliminating measurements. For example, if you have penciled a cutline on a workpiece, you can place the workpiece against the fence and use the manual controls to align the cut line to the blade.

To adjust the rip fence manually:

1. Press the cutting width [ ] key.

   The indicator light on the key shines to show that the control panel is ready to accept input.

2. Use the plus [+] or minus [−] key to manually position the rip fence. (Bump the keys for small adjustments and hold the keys down for large adjustments.)

3. When finished, press the Stop [Stop] key, so the indicator light stops shining.

Numerically Adjusting Rip fence

You can enter a desired cutting width with the number keys and the rip fence will automatically adjust to the specified distance away from the blade.

To adjust the rip fence automatically with numerical input:

1. Press the cutting width [ ] key.

   The indicator light on the key shines to tell you that the control panel is ready to accept your input.

2. Enter the desired cutting width with the number keys.

   As you press the keys, the display will flash the numbers you have entered. If you press a wrong number or make a mistake with your input, press the clear [C] key and start over.

   Example: If you want the cutting width to be 18.25", then you would press the following keys: [1] [8] [·] [2] [5], and the display would look similar to **Figure 11**.

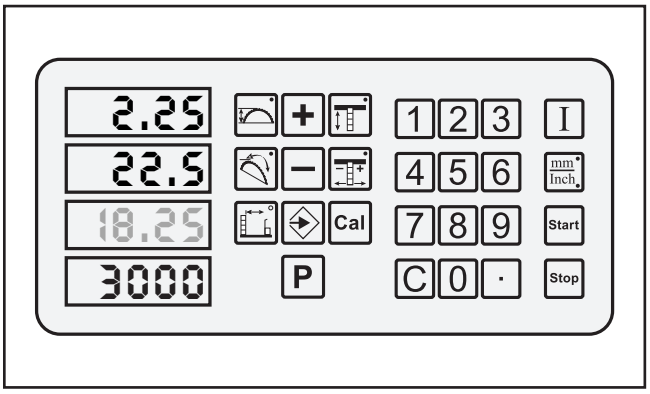

Figure 11. Example of 18.25" entered into rip fence cutting width display.

3. Press the Start [Start] key. The control panel accepts your input, moves the rip fence to the desired distance away from the blade, and the indicator light on the rip fence key stops shining.

NOTICE

If the numerical input exceeds the component limit, it will not completely move, and may return an "OL" on the display.

Combining Adjustment Entries

The controller has the ability to combine numerical input entries of the blade height, blade tilt, and rip fence without closing the input cycle after each entry. This is typically the most efficient way to set up a new cut.

To enter multiple entries, follow the same steps for numerical adjustments with each control, but wait to press the Start [Start] key until after the last control input has been entered.

Example: If you want to set up a cut with a blade height of 2.25", a blade tilt of 22.5°, and a cutting width of 18.25", you would do the following steps:

1. Press the blade height key.

The indicator light on the blade height key shines to show that the control panel is ready to accept input.

2. Use the number keys to enter the blade height (**Figure 12**).

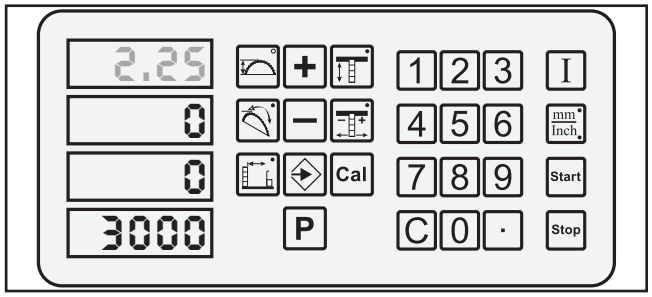

Figure 12. First entry.

3. Press the blade tilt key.

The indicator light on the blade tilt key shines to show that the control panel is ready to accept input. The indicator light on the blade height key no longer shines, but the numbers previously entered still flash.

4. Use the number keys to enter in the blade angle (**Figure 13**).

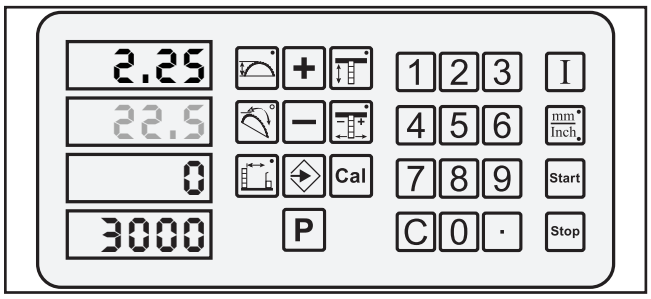

Figure 13. Second entry.

5. Press the cutting width key.

The indicator light on the cutting width key shines to show that the control panel is ready to accept input. The indicator light on the blade tilt key no longer shines, but both numbers previously entered continue to flash.

6. Use the number keys to enter the cutting width (**Figure 14**).

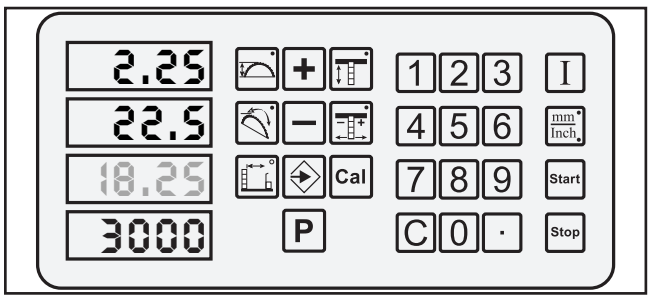

Figure 14. Third entry.

7. Press the Start [Start] key.

All components will move to their respective positions and the indicator light on the cutting width key will stop shining.

Memory Functions

The Model G0620 controller can store up to 29 different cut settings. Each cut setting will save positions for the blade height, blade angle, and rip fence cutting width.

Saving Cut Settings

1. Move the blade height, blade angle, and rip fence to the positions that you want to save. (Refer to **Combining Adjustment Entries** for more details on how to enter all these dimensions at one time.)

For Example: *Set the blade height to 2.25", the blade angle 22.5, and the rip fence position 18.25", as shown in* ***Figure 15****.*

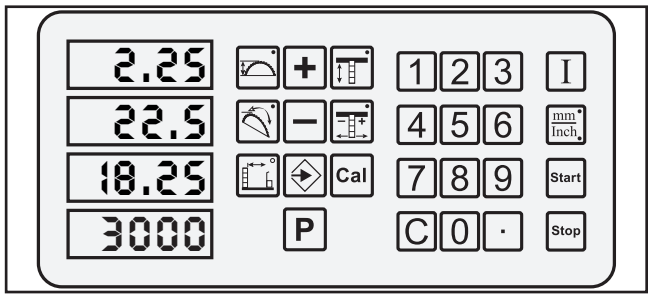

Figure 15. Example dimensions entered.

2. Press and hold the memory set ⟐ key until "S" displays in the blade speed display and the other numbers flash, as shown in **Figure 16**.

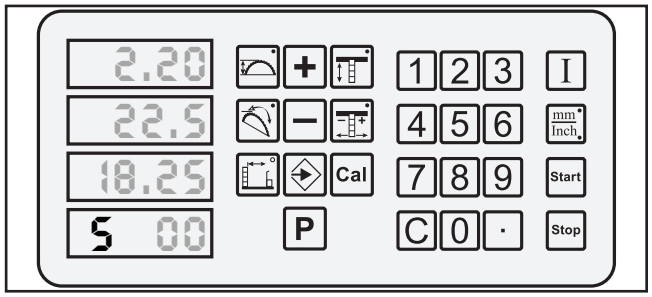

Figure 16. "S" displayed on control panel to indicate system is ready to save settings.

3. Type in a number between 1 and 29 to represent this saved setting.

Use the number 22 to save the example dimensions from **Step 1**. The display should look like **Figure 17**.

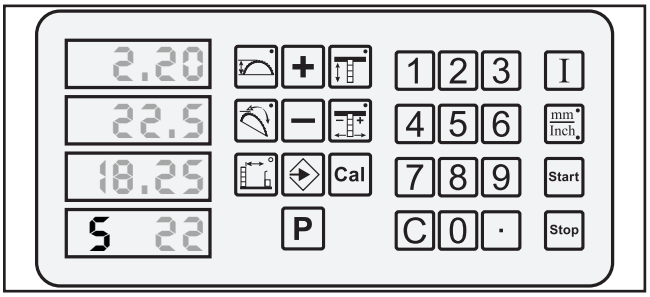

Figure 17. The number 22 programmed to save the currently shown dimensions.

4. Press and hold the input confirmation I key until the display stops flashing. The screen will return to the normal view, as shown in **Figure 18**.

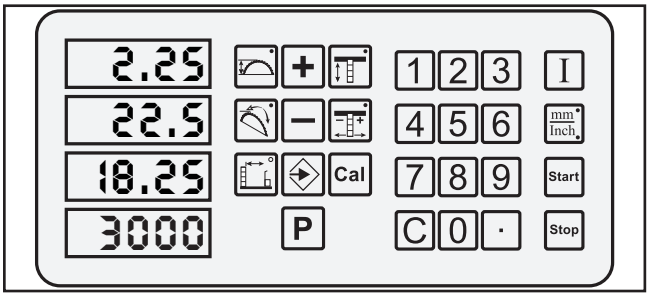

Figure 18. Screen returned to normal view.

Recalling Pre-Saved Settings

To demonstrate how saved settings are recalled, move the components to the following positions before beginning this procedure: blade height to 0.00, blade tilt to 0.0, rip fence position to 10.00. (Refer to **Combining Adjustment Entries for** more details on how to enter all these dimensions at one time.)

To recall a saved setting:

1. Press and hold the pre-saved memory P key until "P" displays in the blade speed display and the memory numbers flash, as shown in **Figure 19**.

NOTICE

If the numerical input exceeds the component limit, it will not completely move, and may return an "OL" on the display.

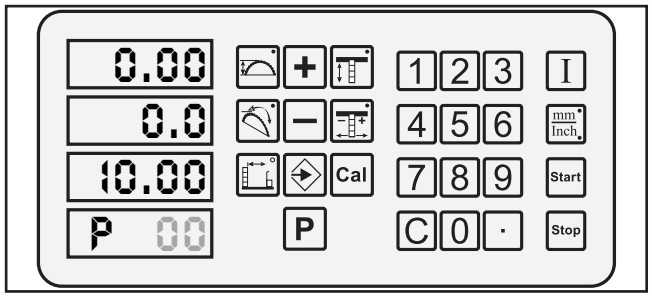

Figure 19. "P" displayed on control panel to indicate system is ready to recall saved settings.

2. Type in the number of the saved setting you want to recall, or use the plus [+] and minus [−] keys to scroll through each saved setting to find the one you want.

Example: *To recall the setting saved in the example of the previous subsection, press the following keys:* [2] [2]*. The display will look similar to* ***Figure 20****, showing the dimensions of each of the three components.*

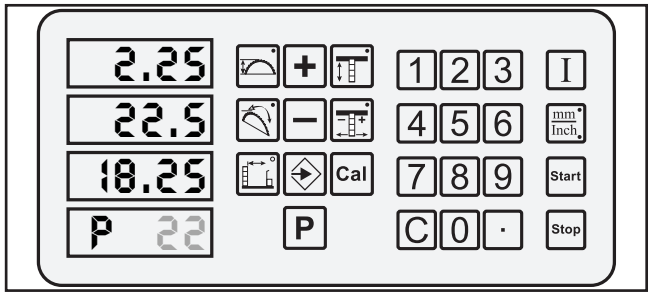

Figure 20. Saved setting 22 entered into the recall display.

4. Press and hold the input confirmation [I] key until the dimensions start flashing, as shown in **Figure 21**.

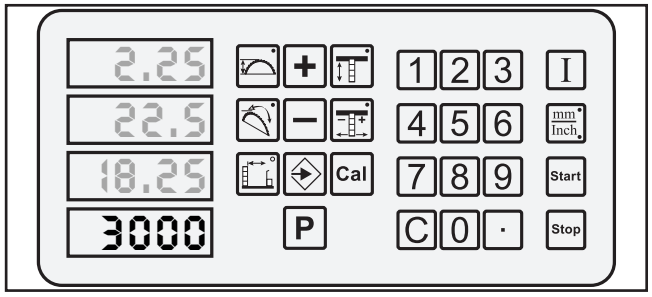

Figure 21. Recalled dimensions flashing.

5. Press the Start [Start] key.

All components will move to their respective positions

Blade Diameter Calibration

The exact dimensions of a blade can be programmed into the control panel, so the blade height controls will not be skewed by blades of different sizes. We recommend performing this calibration procedure every time you change blades, especially if changing between 12" and 14" blades.

Tools Needed	**Qty**
Measuring Tape	1

To calibrate the control panel for your exact blade diameter:

1. DISCONNECT SAW FROM POWER.

2. Remove blade, measure its diameter, then reinstall it.

3. Connect saw to power, reset stop button, turn ***ON*** the control panel, then turn it ***OFF***.

4. Press and hold the blade height [ ] and calibrate [Cal] keys at the same time, then turn the control panel back ***ON***. After a few seconds, the current blade diameter will flash and the display will look similar to **Figure 22**.

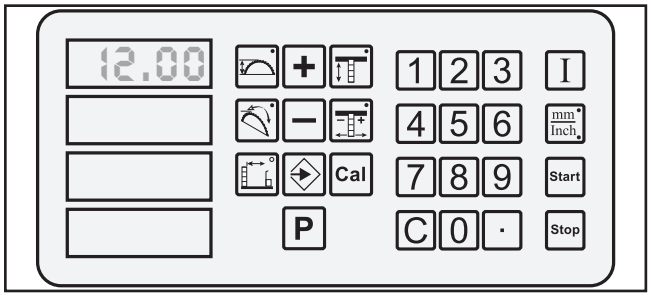

Figure 22. Blade diameter display.

5. Press the clear key [C], then type in the exact dimensions of your blade with the number keys.

6. Press and hold the input confirmation [I] key until the display changes to the normal view.

Blade Height Calibration

Performing this procedure ensures that the blade height displayed in the digital control panel is accurate.

We recommend calibrating the blade height every time the blade is changed.

The calibration is a simple procedure that only takes minutes. For precise results, use a pair of calipers to take the measurements noted below.

Note: *You can stop the calibration process at any time by pressing the Stop [Stop] key.*

Tools Needed	**Qty**
Calipers (Dial or Digital)	1

To calibrate the blade height:

1. DISCONNECT SAW FROM POWER!

2. Rotate the main blade so one of the carbide teeth is at top dead center.

3. Measure the distance from the top of the table to the top of the blade tooth, as shown in **Figure 23**.

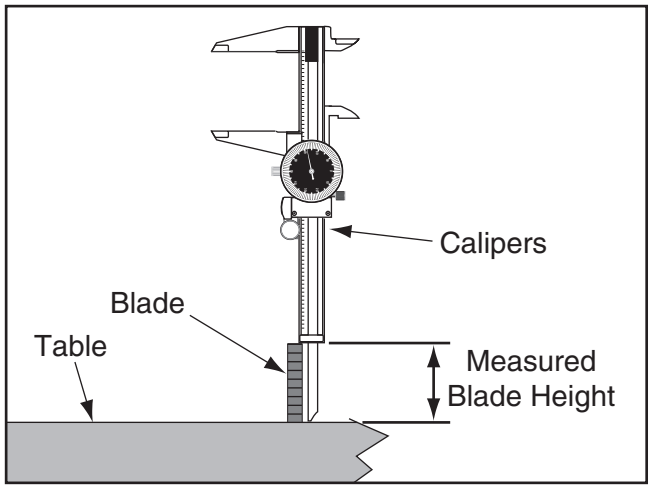

Figure 23. Measuring blade height with calipers.

4. Clear the calipers and any other objects away from the blade, then connect the saw to power.

5. Look at the current blade height displayed on the control panel and compare that to your measurement.

—If the blade height displayed is the same as your measurement, then the blade height calibration is already correct.

—If the displayed blade height is different than what you measured, continue to the next step to calibrate the blade height.

6. Press the blade height [] key.

The indicator light on the key shines to tell you that the control panel is ready to accept input for a new blade height.

7. Enter your measurement with the keypad.

As you press the keys, the display will flash the numbers you have entered.

Example: If you measured 2.15", then you would press the following keys: [2] [·] [1] [5], and the display would look similar to **Figure 24**.

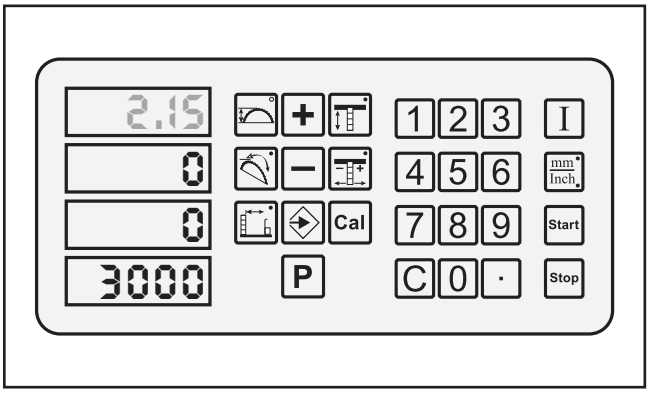

Figure 24. Example of 2.15" entered into the blade height display.

8. Press and hold the input confirmation [I] key until the display stops flashing.

The indicator light stops shining to tell you that the control panel will no longer accept input for the blade height.

Blade Tilt Calibration

Performing this procedure ensures that the blade tilt displayed in the digital control panel is accurate.

The calibration is a simple procedure that only takes minutes.

Note: *You can stop the calibration process at any time by pressing the Stop [Stop] key.*

Tools Needed **Qty**
45° Square 1

To calibrate the blade tilt:

1. Move the overhead blade guard out of the way.

2. Raise the main blade as high as it will go.

3. Tilt the blade to 45°.

4. Place the 45° square flat on the table, push it up against the blade (make sure it does not contact a carbide tooth), and examine how the square fits against the blade.

   —If the square fits flat against the blade, then the blade tilt calibration is already correct.

   —If the square does not fit flat against the blade (you can see a gap between the square and the blade), then continue to the next step to calibrate the blade tilt.

5. Press the blade tilt [] key. The indicator light on the key shines to show that the control panel is ready to accept input.

6. Use the plus [+] or minus [−] key to manually position the blade tilt so it fits flat against the 45° square while the 45° is flat against the table, as shown in **Figure 25**.

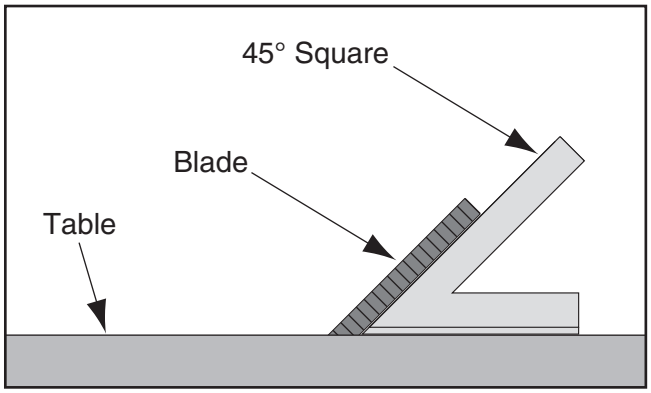

Figure 25. 45° Square flat against table and blade.

7. Press the number [4] and [5] keys to enter 45 degrees into the display.

8. Press and hold the input confirmation [I] key until the display stops flashing.

   The indicator light stops shining to tell you that the control panel will no longer accept input for the blade height.

9. Return the blade position and blade guard back to their original position.

Rip Fence Cutting Width Calibration

Performing this procedure ensures that cutting width from the rip fence accurately matches what is shown in the digital display.

We recommend calibrating the blade height every time you change the blade.

The calibration is a simple procedure that only takes minutes. For precise results, use a pair of calipers to take the measurements noted below.

Note: *You can stop the calibration process at any time by pressing the Stop [Stop] key.*

Tools Needed	**Qty**
Calipers (Dial or Digital)	1

To calibrate the rip fence cutting width:

1. Raise the blade up to 2.25" high, tilt the blade to 0.0, and move the rip fence 4" away from the blade.

2. Measure the distance from the blade to the fence by either making a test cut and measuring the result or by using a pair of calipers.

—If using a test cut to measure this distance, make the test cut, measure your cut workpiece, then proceed to **Step 7**.

—If using calipers to make your measurement, proceed to **Step 3**.

3. Completely close your calipers and make sure they are at 0.000" (if not, zero them now).

4. DISCONNECT SAW FROM POWER!

5. Close the calipers on one of the carbide teeth on the main blade, then zero the calipers out. (This will automatically subtract the blade thickness when measuring the cutting width in the next step.)

6. Place the bottom of the calipers on one of the carbide teeth and extend the caliper measurement bar to touch the rip fence, as shown in **Figure 26**, then lock the calipers in place and read the measurement.

—If the measurement on the calipers reads 0.02" or less away from 4", then the rip fence cutting width calibration is already correct.

—If the measurement on the calipers reads more than 0.02" away from 4", then the rip fence cutting width must be recalibrated. Continue to the next step.

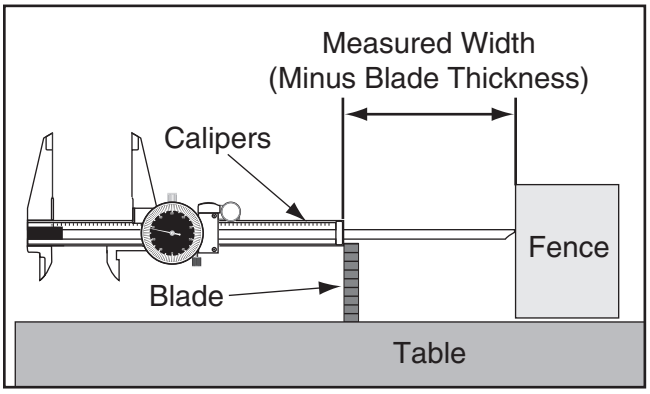

Figure 26. Measuring cutting width with calipers.

7. Press the cutting width [⌗] key. The indicator light on the key shines to show that the control panel is ready to accept input.

8. Enter your measurement from **Step 5** with the keypad.

As you press the keys, the display will flash the numbers you have entered.

For Example: *If you measured 4.15", then you would press the following keys:* [4] [·] [1] [5].

9. Press and hold the input confirmation [I] key until the display stops flashing. The new setting now remains on the display.

Rip Fence Thickness Calibration

The rip fence can fit on the base in two positions, as shown in **Figures 27 and 28**. When the fence is changed from one position to another, the control panel automatically adjusts the dimensions shown on the display so the cutting width remains accurate. The control panel recognizes the fence positions as A and B, as shown below.

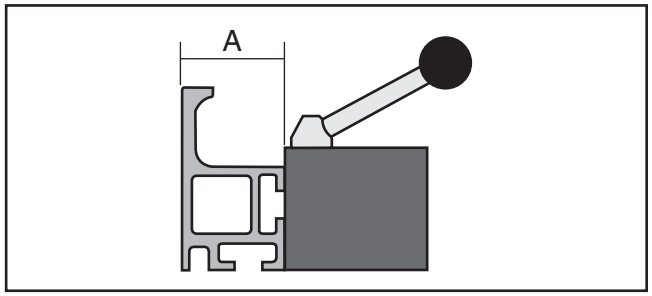

Figure 27. Fence position A.

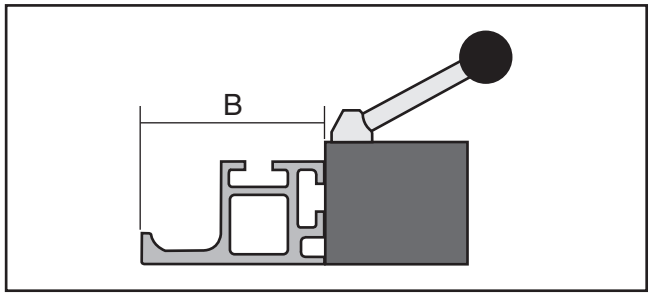

Figure 28. Fence position B.

Besides ensuring that the standard fence dimensions are calibrated correctly. The calibration function can also be used if a sacrificial fence is attached to the standard rip fence.

To calibrate the rip fence thickness:

1. Turn the control panel ***OFF***.

2. Push and hold the blade width and CAL [Cal] keys, then turn ***ON*** the control panel. The display will show A and B dimensions, as shown in **Figure 29**.

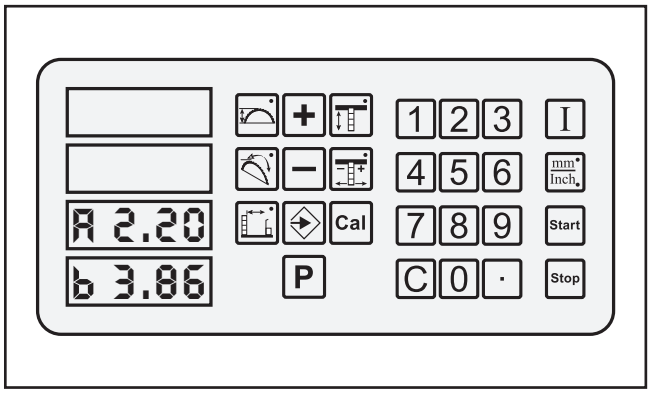

Figure 29. Rip fence calibration mode.

3. Press the clear key [C], then type in the exact dimensions of your fence with the number keys.

4. Type in a new dimension in the A line or press the minus key to activate the B dimension.

5. After entering the new dimension, press and hold the input confirmation [I].

   The numbers you entered are now stored into the control panel as the correct fence thickness.

FENCE OPERATIONS

Control Panel Identification

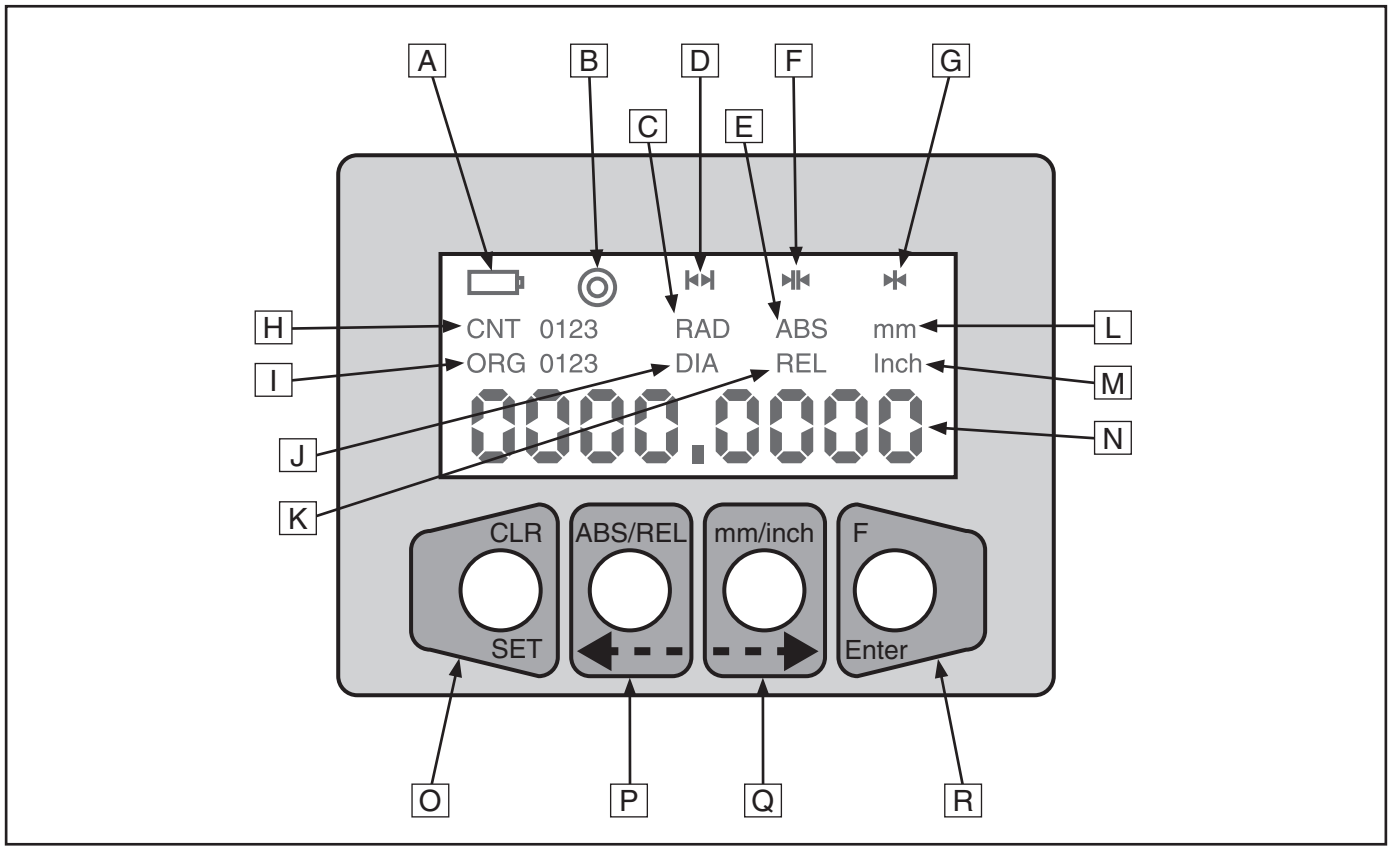

Figure 30. Control panel identification.

A. Low Battery Sign
B. *Angular Measuring Sign
C. *Angular Mode
D. *Increase Gap Sign
E. Absolute Mode
F. *Decrease Gap Sign
G. Function Key Activated Sign
H. *Current Relative Counter Number
I. Current Absolute Counter Number (Memory Slots for Storing Offsets)
J. *Diameter Function
K. *Relative Measuring Mode
L. Millimeter Unit Display Mode
M. Inch Unit Display Mode
N. Numeric Display
O. Clear/Set Key
P. ABS/REL Key
Q. MM/Inch Key
R. Function/Enter Key

** Not applicable for this machine. Refer to the **Foreword** at the beginning of this manual for details.*

MM/Inch Selection

The controller can display units in millimeters or inches.

To toggle the display between mm and inches, press the mm/inch key (**Figure 31**) until the new unit of measure shows on the control panel.

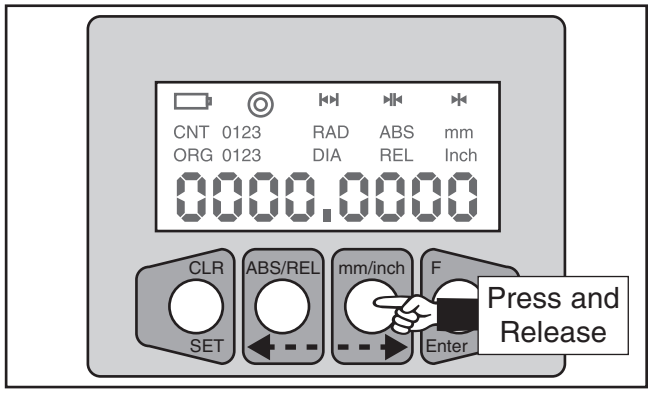

Figure 31. Pressing mm/inch key to toggle the displayed unit of measure.

Checking Battery

To check the remaining battery charge:

1. Press and hold the F/ENTER key (the ⏭ sign will appear as this key is held down), then press and release the mm/inch key.

   The controller displays the remaining charge left in the battery, as shown in **Figure 32**.

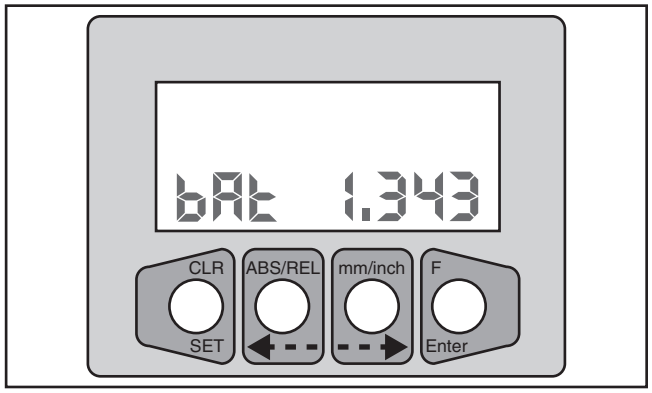

Figure 32. Current battery charge displayed.

   The display will automatically exit out of the battery charge screen after two seconds.

Changing Resolution

The display can be adjusted to show a resolution or accuracy from one to four decimal places, depending on which unit of measure is selected.

To change the resolution:

1. Press and hold the F/ENTER key (the ⏭ sign will appear as this key is held down), then press and release the mm/inch key.

   The controller displays the remaining power left in the battery, as shown in **Figure 32**.

2. At the battery charge display screen, press the CLR/SET key and the F/ENTER key at the same time.

   The controller displays the resolution, as shown in **Figure 33**.

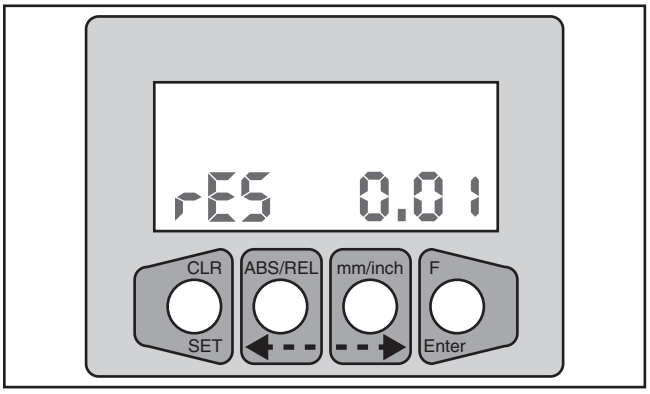

Figure 33. Resolution displayed to two decimal places.

3. Use the left and right arrows on the ABS/REL and mm/inch keys to select the desired resolution.

4. Press the F/ENTER key to exit.

Calibrating the Display

The controller can be calibrated to match the actual measured distance from the blade to the controller flip stop. This calibration is critical to ensure that cutting results with the crosscut fence are accurate.

To calibrate the controller:

1. Move the flip stop to the side of the fence that would touch the workpiece, and measure the distance between the flip stop and the blade.

2. Press the ABS/REL key, then release it to make sure the controller is in the ABS mode.

3. Press and hold the CLR/SET key (the ⏯ sign will appear), then press and release the ABS/REL key, then release the CLR/SET key.

   The controller will display a small flashing "0", which signals that it is ready to accept input (see **Figure 34**).

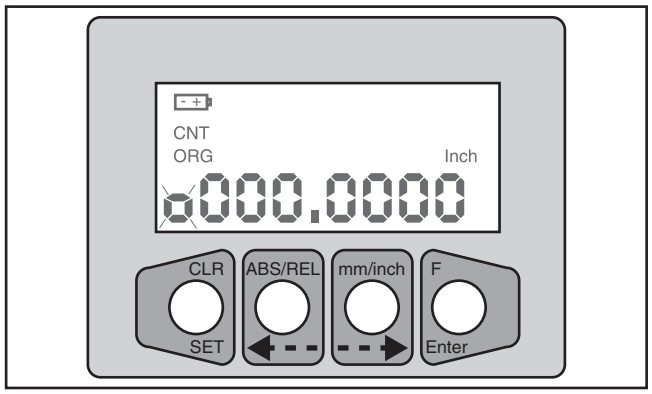

Figure 34. Display screen ready to accept numerical input for calibration.

4. Use the left and right arrows on the ABS/REL and mm/inch keys to choose which digits to modify.

   Modify the digits by pressing the CLR/SET key when the chosen digit is blinking. When you are done, the number on the controller should match the measurement you took in **Step 1** (see **Figure 35** for confirmation).

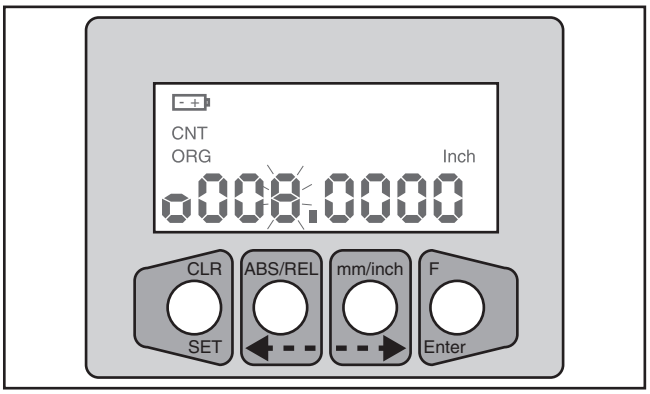

Figure 35. Numerical input of 8" entered for calibration.

5. Press the F/ENTER key to save the current number in the controller as the "calibrated" measurement. The controller is now calibrated to be accurate from the flip stop to the saw blade.

   —If the calibrated distance is shown on the display, no further steps are necessary.

   —If the calibrated number is not shown, continue to **Step 6**.

6. Press the ABS/REL key, then release it to make sure the controller is in the ABS mode.

7. Press and hold the F/ENTER key (the ⏯ sign will appear while this key is held down), then press and release the CLR/SET key, then release the F/ENTER key.

Using Offsets

The crosscut fence includes three origin blocks located inside the channel where the stop blocks slide in the fence.

The origin block closest to the blade is the "Home" origin block for the digital stop, which is always used in conjunction with the other two origin blocks when the second stop block is used. Using the second stop block with the origin blocks is the only way to get a digital reading with the second stop, and hence, when using the fence extension (**Figure 36**).

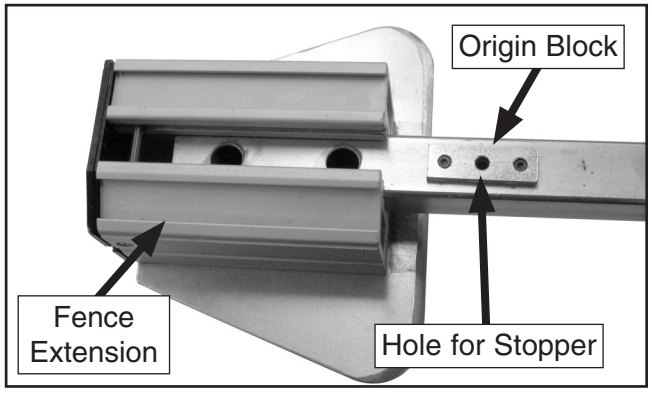

Figure 36. Origin block near fence extension.

It works like this: the stopper in the digital stop block is dropped into the home origin block. This locks the digital stop block to the sliding plate inside the fence. The second stop block is then moved to one of the two origin blocks and locked using a similar stopper (**Figure 37**). The display on the digital stop block is then changed to one of the "ORG" settings, resulting in the display reading the position of the second stop block, rather than the position of the digital stop block.

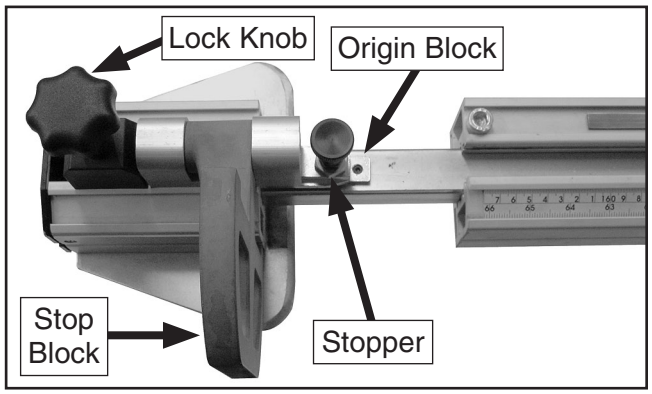

Figure 37. Second stop block engaged in origin block near fence extension.

Basically, the display shows the dimension of the second stop block because it adds a pre-programmed offset distance from one origin block to the other.

Aside from the two origin block offsets, two additional offsets can be programmed in the controller to be used with jigs or measurement blocks.

Entering Offset Values

1. Press and hold the F/ENTER key until the "Origin" screen appears as in **Figure 38**.

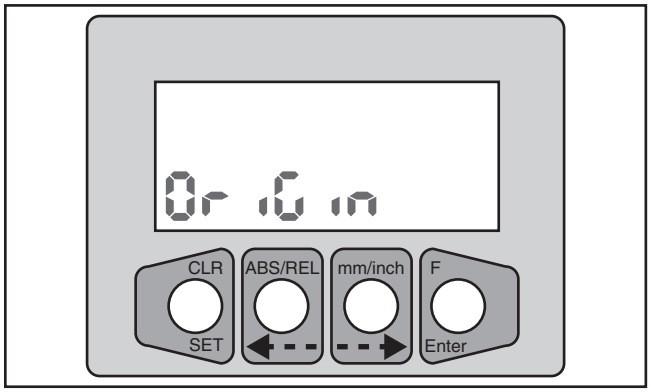

Figure 38. Origin screen.

2. Press the right arrow key (mm/inch key) twice until the display shows the word "Offsets" as in **Figure 39**.

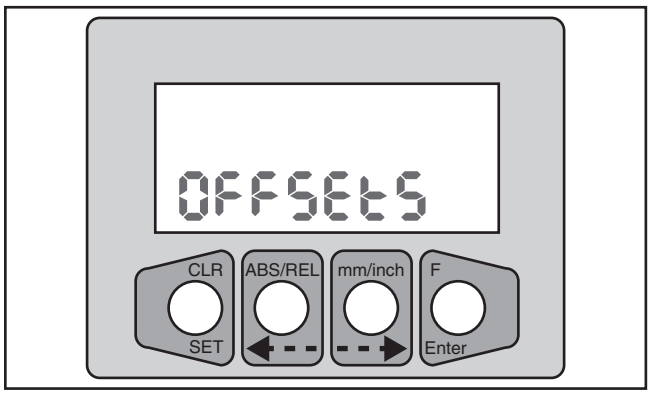

Figure 39. Offsets screen

3. Press the F/ENTER key.

"Select" appears on the display (**Figure 40**) with "ORG" and a number next to it, prompting you to select which ORG to program.

Note: *When programming "ORG 0," put the digital stop block stopper in the home origin block (the closest one to the blade) and put the second stop block stopper in the origin block closest to the home origin block. Measure the distance from the usable face of the digital stop block to the usable face of the second stop block, and program that distance into the controller. When programming "ORG 1," move the second stop block to the origin block near the fence extension and repeat.*

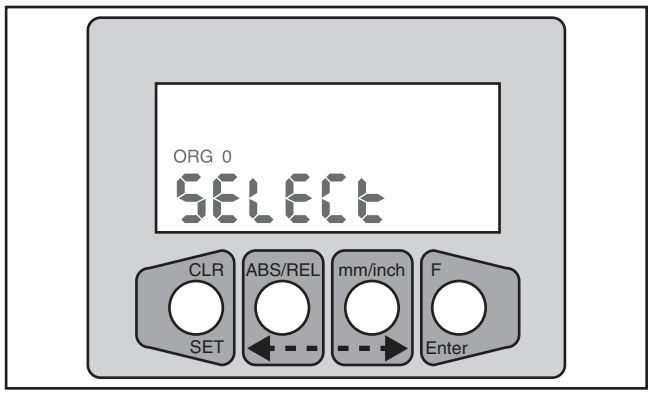

Figure 40. ORG select screen.

4. Use the arrow keys to select which ORG to program, then press the F/ENTER key.

The display changes to an entry screen with a flashing "0", as shown in **Figure 41**. (Due to resolution settings, the number of zeros displayed may not match the figure exactly.)

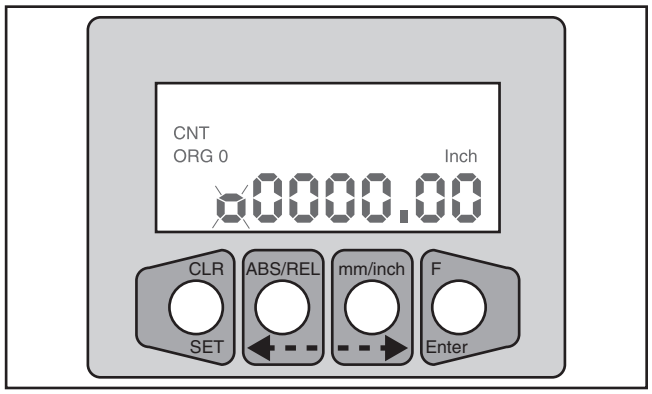

Figure 41. Controller ready to enter a value for ORG 0.

5. Use the left and right arrows on the ABS/REL and mm/inch keys to select the digit you want to modify.

Modify the digits by pressing the CLR/SET key when the desired digit is blinking.

The smaller 0 at the far left of the number represents a positive value, but can be modified to a negative value if desired by pressing the CLR/SET key when it is blinking.

6. Press the F/ENTER key to save the current number in the controller.

The display will go back to the "Select" screen. From this screen, you can enter additional cutoff values by repeating **Steps 4-5**.

7. To exit the "Select" screen, press the CLR/SET key.

The display will go back to the "Offsets" screen.

8. To exit the "Offsets" screen, press the CLR/SET key.

Activating Stored Offsets

1. Press and hold the F/ENTER key, then press the ABS/REL key to cycle through the ORG numbers.

The offset value is automatically applied to the current value displayed when the related ORG number is selected.